Work Orde									-		Page 1
Item ID: Revision ID:	D3535-37			Accept					Setup St	tart	
	Wearshoe 3/28/2011 3/31/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item 1 Customer:	ID:			S	top	
Approvals:	Process Pla	n:	Date: <u>//-03-</u> _}	Tooling: SPC (Y/N):		ate:	-	I		tart	
Sequence ID/ Work Center ID	,	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Čode	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3535	Rev	В									
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Waterjet FLOW CNC Waterje 304.040	t	Memo 1-Cut as p Deburr if	per Dwg D3535 □Dwg Rev necessary	0.00 : S □Prog Rev:_	<u>R</u>	ginar Tiri				<u>(6)</u>	
		QC2- Inspect parts off	machine FAI/FAIB	0.00			v	ינו	1-4-5	5	
QC Quality Control		Memo		0.00							

120

Quality Control

QC8- Inspect parts - second check

Memo

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CH	HANGES					•
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Work Order ID 67612



Page 2

Monday, March 28, 2011 2:30:34 PM

Item ID:

D3535-37

Accept



Setup Start





Revision ID:

Item Name:

Wearshoe

Start Date:

Start Qty: 6.00 3/28/2011

Required Date: 3/31/2011

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Run

Start

Stop

Stop



Operation

Description

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Date:

Accept Qty

Code

Reject Qty

Reject Insp. Number Stamp

Work Center ID 130

Sequence ID/

Brake NC

Brake NC

NC BRAKE

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. \Box 2- Identify as D3535-37

140

Quality Control

QC5- Inspect part completeness to step on W/O

5 worls

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

Memo

0.00

□OVEN TEMPERATURE:

6 Bl 11-4-6.

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval QC Inspector PROCEDURE CHANGE DATE STEP By Qtv Chief Eng / Prod Mgr Date Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

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NOTE: D	ate & initia	al all entries						

Work Order ID 67612

Monday, March 28, 2011 2:30:34 PM



Page 3

Item ID:

D3535-37

Accept

Setup Start



Revision ID:

Item Name: **Start Date:**

Wearshoe

3/28/2011

Start Qty: 6.00

Required Date: 3/31/2011

Req'd Qty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Approvals:

Sequence ID/

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Reject Accept Qty

Reject

Insp. Number Stamp

160

Work Center ID

QC

Memo

QC3- Inspect Part Finish

0.00

0.00

Qty

6 d 11/01/02 y

Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location: 18

Memo

0.00

0.00

6 Bl W-4-7

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					7
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Monday, March 28, 2011 2:30:40 PM

Work Order ID: 67612

Parent Item:

D3535-37

Parent Item Name:

Wearshoe



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	109.0000	0.7955	5.024211			
										181	1-4-5		

304/316 .040 Sheet

Location	Loc Qty	Loc Code		<i>c</i> >
MAT020	109			(r)
115953	1		<u></u>	(6)
116437	44		16437	
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DART AEROSPACE LTD	Work Order:	47412
Description: Wearshoe	Part Number:	D3535-37
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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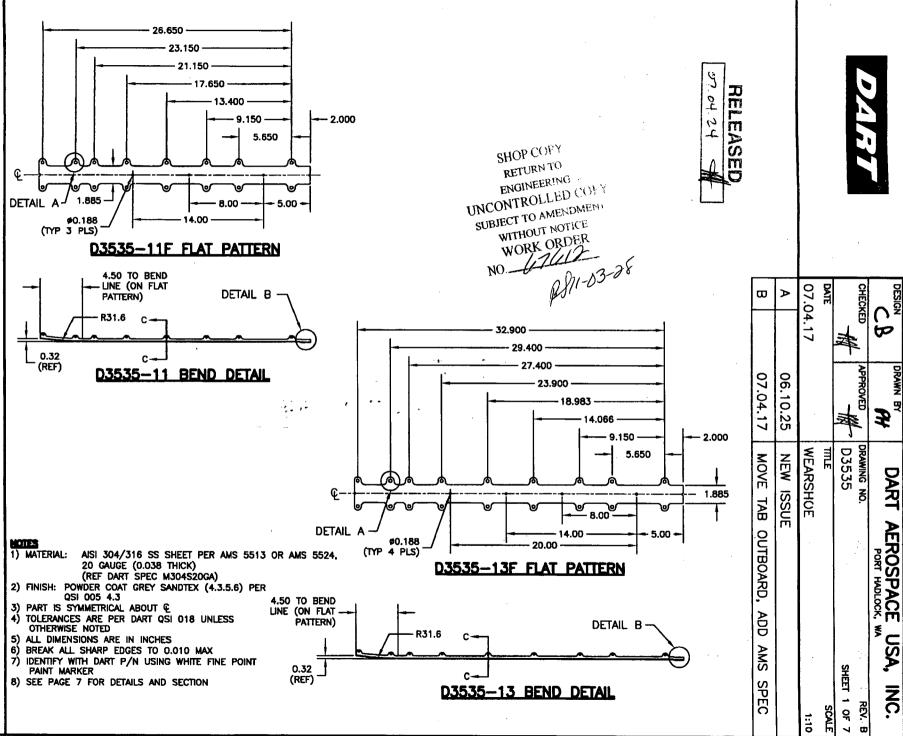
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Dart Aerospace Ltd

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PURPOSE

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Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr Prod Mgr QC Inspector Approval QC Inspector

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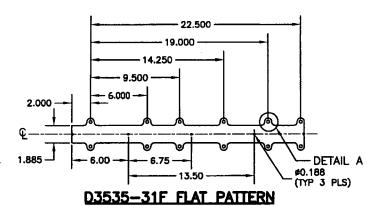
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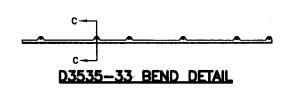


D3535-31 BEND DETAIL

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	13.50 (TYP 3 PLS)
	D3535-33F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT € 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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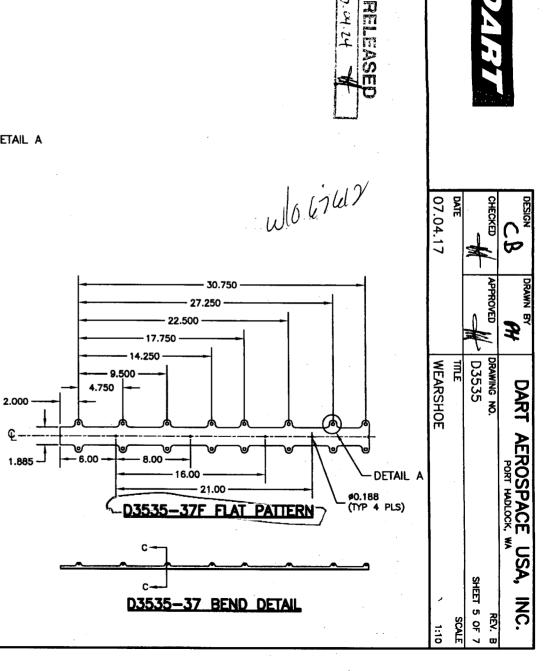
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D3535-35 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWERS COAT GREY SANDTEX (4.3.5.6) PER

- QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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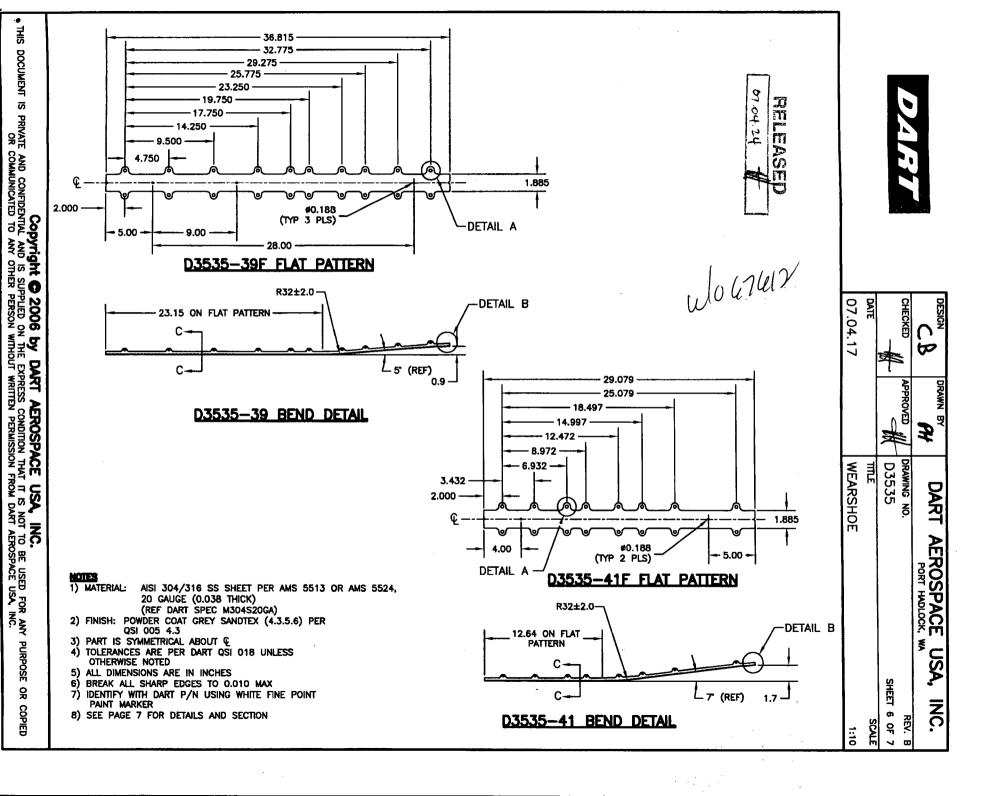
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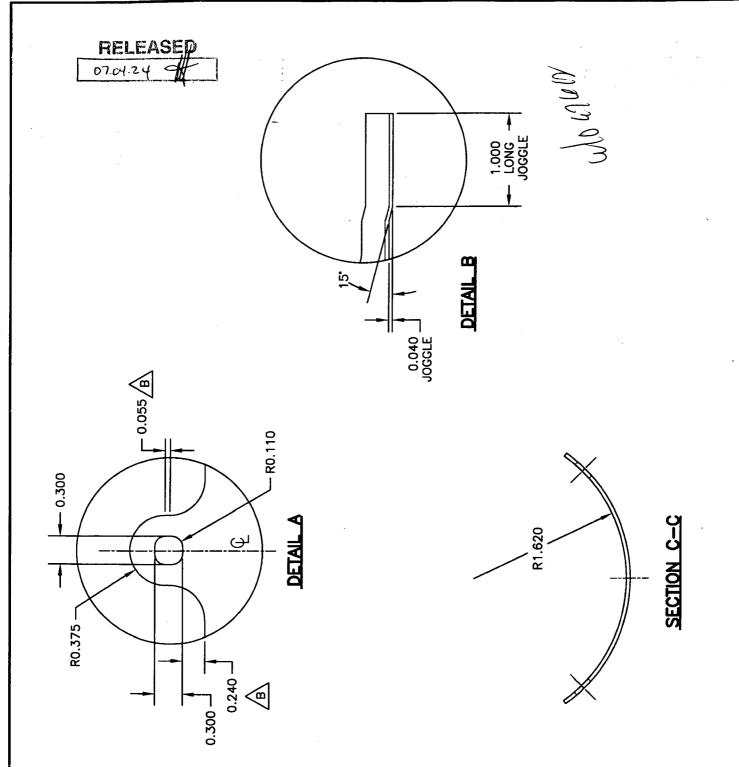
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